



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D117-762-041
Job Sheet 199092



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Due Date: 9/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV.C (ecn16-514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs		9/4/19	0.00	3.30	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs		9/4/19	0.00	3.30	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	pcs		9/4/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
160	QC 5	pcs		9/4/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		

PRIORITY

DAS
AUG 21 2019
9:50

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	AUG 21 2019
					QC 5 - 9	DAS 68
					QC 5 - 50	9.89
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					170 Handfinish - 1-1 Chemical- B4B	1 pcs
Handfinish - 1 - 2 - B4B						
Handfinish - 1 - 3 - B4B						
Handfinish - 1 - 4 - B4B						
Handfinish - 1 - 5 - B4B						
Handfinish - 1 - 6 - B4B						
Handfinish - 1 - 7 - B4B						
Handfinish - 1 - 8 - B4B						
Handfinish - 1 - 9 - B4B						
Handfinish - 1 - 10 - B4B						
Handfinish - 1 - 11 - B4B						
Handfinish - 1 - 12 - B4B						
Handfinish - 1 - 13 - B4B						
Handfinish - 1 - 14 - B4B						
Handfinish - 1 - 15 - B4B						
Handfinish - 1 - 16 - B4B						
Handfinish - 1 - 17 - B4B						
Handfinish - 1 - 18 - B4B						
Handfinish - 1 - 19 - B4B						
Handfinish - 1 - 20 - B4B						
Handfinish - 1 - 21 - B4B						
Handfinish - 1 - 22 - B4B						
180 QC 7	1 pcs	9/4/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	BE
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
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					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
190	Skidtubes - 3 - B4B	1 pcs	9/4/19	0.00 3.33	Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
200	QC 10	1 pcs	9/4/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	SEP 03 2019 DAS 50 9-89
					QC 10 - 58	
					QC 10 - 9	
210	QC 5	1 pcs	9/4/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	SEP 03 2019 DAS 68 9-89
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
215	Handfinish - 2-1 Pressure- B4B	1 pcs	9/4/19	0.00 0.97	Handfinish - 2 - 1 - B4B	SEP 04 2019
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
220	Powdercoat - 1 White Gl(A)- B4B M193459.	1 pcs	9/4/19	0.00 0.26	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BP 19-9-4.
					Powdercoat - 4 - B4B	
230	QC 3	1 pcs	9/4/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	

				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BEB19-09-05
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250	Handfinish - 4-1-Assembly-B4B	1 pcs	9/4/19	0.00 0.97	Handfinish - 4 - 1 - B4B
					Handfinish - 4 - 10 - B4B
					Handfinish - 4 - 11 - B4B
					Handfinish - 4 - 12 - B4B
					Handfinish - 4 - 13 - B4B
					Handfinish - 4 - 14 - B4B
					Handfinish - 4 - 15 - B4B
					Handfinish - 4 - 2 - B4B
					Handfinish - 4 - 3 - B4B
					Handfinish - 4 - 4 - B4B
					Handfinish - 4 - 5 - B4B
					Handfinish - 4 - 6 - B4B
					Handfinish - 4 - 7 - B4B
					Handfinish - 4 - 8 - B4B
					Handfinish - 4 - 9 - B4B
260	QC 5	1 pcs	9/4/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
270	Packaging 3-1 - Stock - B4B	1	9/4/19	0.00 0.00	Packaging 3 - 1 - B4B

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pcs				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	9/4/19	0.00 0.00	DC - 1 - B4B	
	pcs			DC - 2 - B4B	
280 QC 21 - FG	1	9/4/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 130 - Skid tubes-1 (Skid tubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16
 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-
 Open wearplate holes to Ø.19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B,
 locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove
 DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875
 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and
 doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine
 on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill.
 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65
 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open
 holes of section G-G to finishes size.

140 - Skid tubes-1 (Skid tubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD
 Batch: 138989/13611 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skid tubes-1 (Skid tubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish
 size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E
 and G-G. ***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for
 welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R
 241 Sike Flex Batch: 5200625 Exp Date: 07/25/2020 6- Swage x-bolt spacer as per dwg and

Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD

Batch: 139011 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME _____ OVEN TEMPERATURE:

FINISH TIME: _____

230 - (QC3- Inspect Part Finish)

250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: 5200625 Exp Date: 20/07 3-Install Wearplates as per Dwg D3582 ,Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4 5116104

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	<u>5171127</u>
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	<u>5171148</u>
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	<u>5146305</u>
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	<u>5157307</u>
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	<u>5097024</u>
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	<u>5174779</u>
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	<u>5173644</u>
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	<u>F81606</u>
D3662-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	<u>5148275</u>
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5057257</u>
ALS4-128-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5147561</u>
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5149158</u>
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5209067</u>
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5148662</u>
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5166570</u>
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5112981</u>
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5172983</u>
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5145470</u>
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5177366</u>
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5177368</u>
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5177344</u>
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5177339</u>
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5193136</u>
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>5178378</u>
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	<u>F1131511</u>
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	

M.U. 011773

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	4	0
	D5520-1	2	22	0
	D2964	1	28	0
140-Skidtubes - 2 - B4B	CR3212-5-05	68	670	0
190-Skidtubes - 3 - B4B	D2971	1	17	0
	D3584-1	1	10	0
	D3662-1	3	31	0
250-Handfinish - 4-1-Assembly-B4B	D3662-3	1	40	0
	D5304-1	2	17	0
	ALS4-1032-130	36	6,816	0
	ALS4-428-165	2	78	0
	AN3-5A	2	82	0
	AN3C4A	28	1,130	0
	AN4-4A	2	59	0
	D2965	1	55	0
	D3508-11	1	16	0
	D3508-13	1	13	0
	D3508-3	1	19	0
	D3508-9	1	16	0
	D3558-11	1	5	0
	D3558-13	1	5	0
	D3558-3	1	5	0
	D3558-9	1	5	0
	NAS1149C0332R	28	3,043	0
	NAS1149D0332J	2	2,515	0
	NAS1149D0416J	2	1,821	0
Part Specifications				
Specifications could not be found.				

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ITEM	Qty	Part Number	Description
	X	D3882-041	SKIDTUBE ASSEMBLY
1	1	D2862-180	EXTRUSION
2	1	D2864	CAP
3	1	D2865	CAP
4	1	D2871	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-8	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-8	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3882-1	CROSS BOLT SPACER
15	1	D3882-3	CROSS BOLT SPACER
16	2	D3884-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3CA4	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NA51148C0332R	WASHER (AN880C10L)
22	2	NA51148D0332J	WASHER (AN880J10L)
23	2	NA51148D0416J	WASHER (AN880J1416L)
24	38	AELS-1032-130	INSERT
25	2	ALST-428-185	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

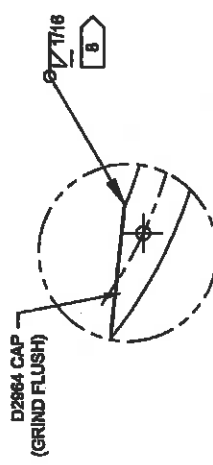
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3884-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.4.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 18.2 lbs
 - 8) WELDING: PER DART QSI 004.
 - 9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241-281 ADHESIVE PER DART QSI 015 AFTER BENDING.
 - 10) USE DART DRILL TEMPLATE D78900 TO LOCATE AND DRILL Ø0.287 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241-281.
 - 11) DO NOT INSTALL AN3CA4 BOLTS AND NA51148C0332R WASHERS IN INDICATED LOCATIONS
 - 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309. COUNTERSINK Ø0.288 x 100" (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

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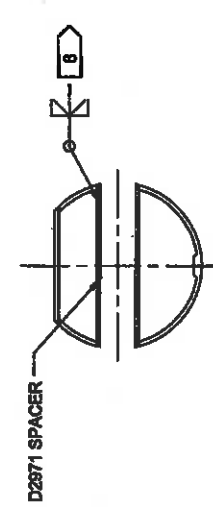
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WITHOUT NOTICE
WORK ORDER
199092 MJS
19-08-12

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 28 AND NOTE 12-13. Ø0.161 HOLE WAS Ø0.78. ADD SHT 3. ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D3884-1 WAS D2871. REVISE BOM & SECTION F-F & SECTION NOTES (ZU 17-3, A8-3). REF NCR18-1160 NOTES SHT 1	RF	17.01.09
C	D3882 PLUG ASSEMBLIES REMOVED. REFORMAT	AP	15.11.02
B	29.05 WAS 23.07 (ZU C2-1). INCORPORATED DEO D3882-A-1 (ZU D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
CHECKED	MKS	DRAWING NO.	
INFO. APPR.	DD	D3882	
APPROVED		TITLE	
DE APPR.		BK 117 SKIDTUBE ASSEMBLY	
DATE	17.03.27	SHEET 1 OF 4	
		SCALE	
		NTS	
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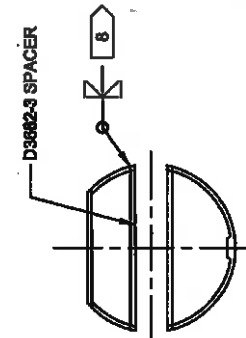


DETAIL C
SCALE 4X



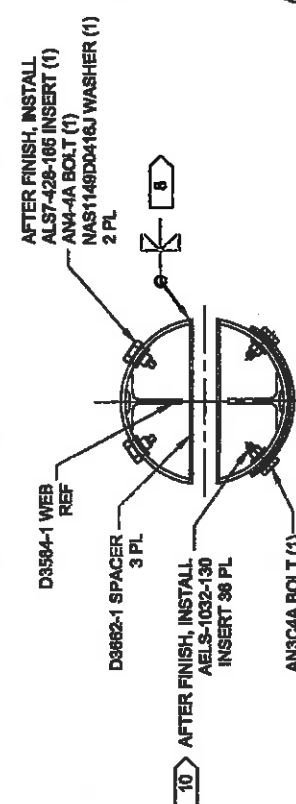
SECTION D-D
SCALE 4X

SECTION D-D NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2871 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER



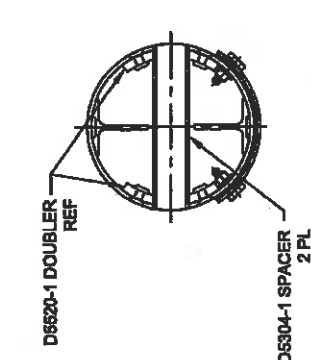
SECTION E-E
SCALE 4X

SECTION E-E NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3862-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER



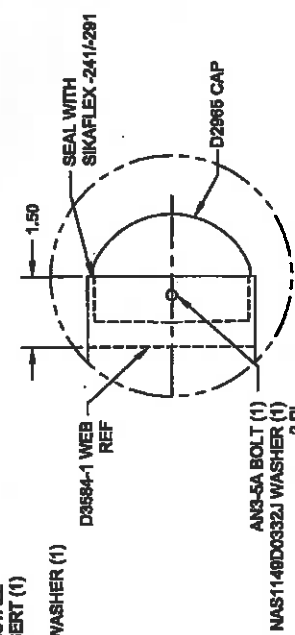
SECTION G-G
SCALE 4X

SECTION G-G NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3862-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER



SECTION F-F
SCALE 4X
2 PL

SECTION F-F NOTES
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D5304-1 SPACER
2. SWAGE TO Ø0.565 ±0.005-0.000 X 1.0
DEEP PER QSI 002
3. OPEN THRU HOLE TO Ø0.825
4. GRIND FLUSH



DETAIL H
SCALE 4X
9

DESIGN	PH	DATE	17.03.27
DRAWN	AUS		
CHECKED	MEAL		
MFG. APPR.			
DE APPR.			
DATE			

DART AEROSPACE USA, INC
EUGENE, OR
DRAWING NO. D3582
SHEET 3 OF 4
TITLE BK 117 SKIDTUBE ASSEMBLY
SCALE NTS
DATE 17.03.27

RELEASED
R 2017-08-11

1 2 3 4 5 6 7 8

Route update only

H:\FORMS\Quality Assurance\approved QA\NCRWO Rev J